

Date: Monday, 12/5/2005 9:26:00 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 25102	
Estimate Number : 10416	
P.O. Number : <i>N/A</i>	Part Number : D31981
This Issue : 12/5/2005 S.O. No. : <i>N/A</i>	Drawing Number : D3198 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/5/2005 Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 24632	Material : <i>N/A</i>
Written By : <i>See comment below</i>	Due Date : 12/20/2005 Qty: 20 Um: Each
Checked & Approved By : <i>See comment below</i>	
Comment : Est: A 03.11.11 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: *00000215*

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3198

Material release note is required

05/12/05

2.0	D31981F	Fitting-Flat
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Fitting

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C205/01/05 125

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK*06-07-05 125*

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3198

SB 06/01/11 125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DE Date: 06/01/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:26:01 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 25102

Part Number: D31981

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-01-11 125

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

7/11 06 01 12 125

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C206101112 125

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 94

C206101112 125

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 20610112 (125)

Job Completion



u 06-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

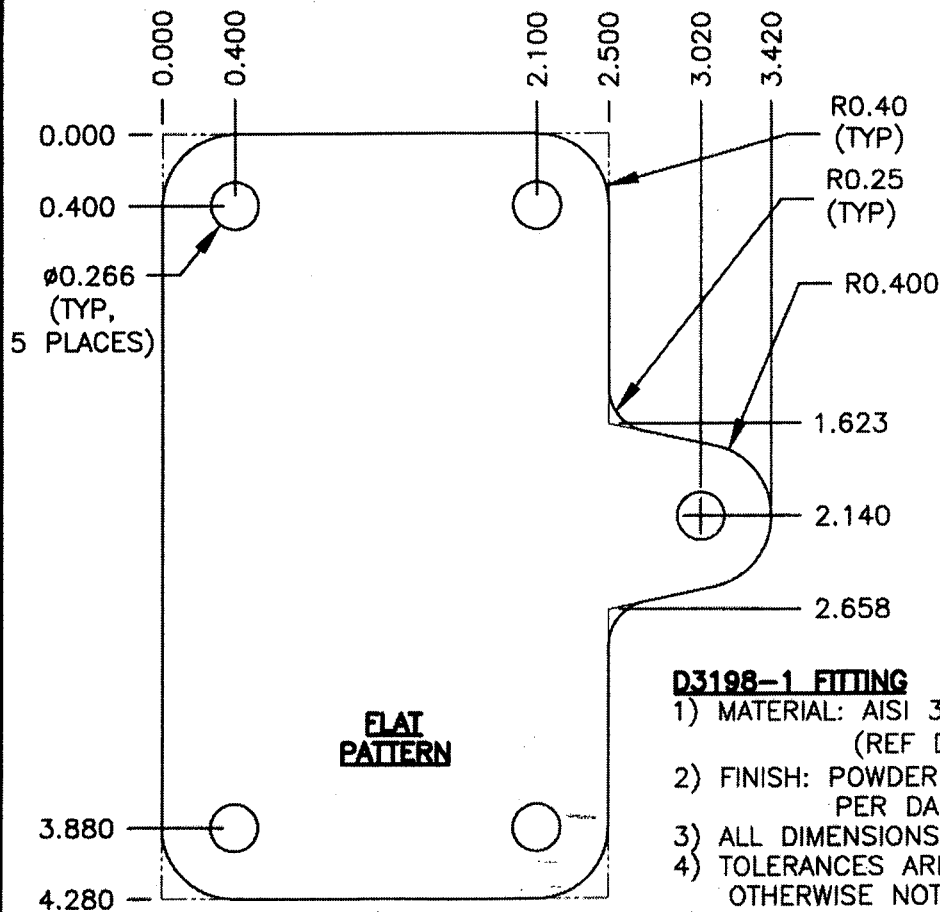
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



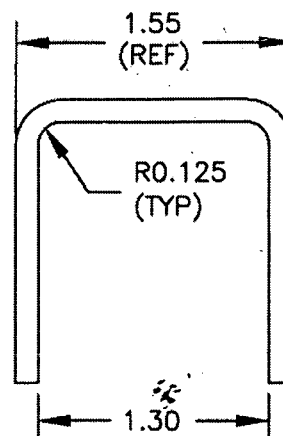
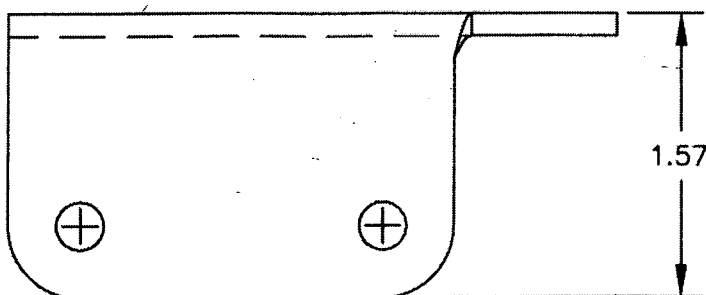
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	



D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10 *[Signature]*



**BEND
DETAIL**

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輝茂實業股份有限公司

YIEH MAU CORP.

INVOICE NO. :

F05M925R

COMMODITY :

PRIME COLD ROLLED STAINLESS STEEL SHEET

MATERIAL TEST/INSPECTION CERTIFICATE

98264027

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIAO
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)8972885 FAX:(07)8973006
CERTIFICATE NO: F05M925R
DATE OF ISSUE:03/31/2006
PAGE:3

SPECIFICATION :

AISI 304

CUSTOMER :

INTEGRIS METALS LTD

SIZE	BUYER'S ITEM NUMBER	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)								
			KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304 2B																				
11GA / 48" X 120"	(7427-6445)	1	1,404	3,095	YU136029	42S56953A-2122	275	680	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 120"	(7427-6445)	1	1,051	2,317	YU136029	42S56953A-2123	275	680	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 96"	(7427-6403)	1	1,398	3,082	YU136785	42S60093B-11	290	659	51	84	169	4.3	47	119	28	9	809	1827	2.9	
AISI 304 NO.4																				
16GA / 36" X 120"	(7426-6064)	1	1,396	3,078	YU282680	41B56329-22111	300	670	50	82	159	4.7	50	122	25	9	805	1813	2.9	

4 5,249 11,572

Remarks:

NO MERCURY CONTAMINATION

Bend test: good for all Heat NO.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A282E, ASME SA240, QQS766D.
P.O. NO.: 494470

YIEH MAU CORP.

Manager of Quality Assurance Section

11 ga 304 2B SS

06.01.09

186 1215, 146, 248, 245